

ship Dec 2.

Work Order ID 153163

153163

Grap

Tuesday, November 08, 2016 1:16:38 PM

Item ID: D5380-1
Revision ID:
Item Name: Support
Start Date: 12/1/2016 Start Qty: 16.00 *16*
Required Date: 12/1/2016 Req'd Qty: 16.00 *16*
Reference:
Cust Item ID:
Customer:

Accept

N900040100

Setup Start *NS1*
Stop *NS2*

Approvals: Process Plan: em Date: 16/11/8 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5380	B

100	HAAS CNC VERTICAL MACHINING #1	0.02							
100									
HAAS 1		8.44							
HAAS CNC vertical machine #1	Memo Machine as per Folio FB458 Folio Rev: <u>AA</u> Dwg Rev: <u>B</u>								
	Deburr								

B.P 16/11/19
DAS 33 9-89
16/11/22

14 2 DAS 08 9-89

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC		0.03							
Quality Control	Memo								

B.P 16/11/19
DAS 33 9-89
16/11/22

(14) (2) DAS 08 9-89

P.T.O.

DQA:

Date:

2017-04-05

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

MAR 10 2017

Work Order update only

Work Order: <u>153163</u> Part No. <u>D5380-1</u> NCR No. <u>17-6339</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☒ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>16-11-19</u>		Step #: <u>100</u>		QTY Effective: <u>2 + 12 (split)</u>		MRB (QSI042) Approval DAS 9 9-89 16-11-23			
Description Work Order Deviation				Disposition					
⊥ on .625" hole is .015" instead of .005" (max) over the entire length of the hole axis in relation of the 2 surfaces within the (3.550") dimension				→ reworked the 2 parts, so the top profiled surfaces (R.650") are now at 0.000" instead of .015" on both parts but it affected 2 dimensions: 2.745" and .538" Part 1: (2.462 to 2.476) (.523) B.P. 16/11/21 Part 2: (2.460 to 2.476) (.524) 16/11/21 after rework dimension .538" was found to be .005" under tolerance, therefore parts are not acceptable. Scrap qty 2 no replace.					
Completed By B.A 16-11-19				Lead hand / Supervisor Approval Verification DAS 9 9-89 16-11-23					
QC / QA Coordinator Approval DAS 9 9-89 16-11-23									
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☒ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ ☒ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER :									

Work Order ID 153163

Tuesday, November 08, 2016 1:16:38 PM

153163

Page 2

Item ID: D5380-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 12/1/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/1/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N) _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120 QC Quality Control	Memo	0.05							
121	QC5- Inspect part completeness to step on W/O	0.00							
121 QC Quality Control	Memo	0.05							
130	Identify as per dwg & Stock Location: _____	0.00							
130 Packaging Packaging	Memo LOCATION : LG054	0.03							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

Work Order ID 153163

Tuesday, November 08, 2016 1:16:38 PM

153163

Page 3

Item ID: D5380-1**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Support**Start Date:** 12/1/2016 **Start Qty:** 16.00***16*****Cust Item ID:****Required Date:** 12/1/2016 **Req'd Qty:** 16.00***16*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.27

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

Tuesday, November 08, 2016 1:16:38 PM

Page 1

Work Order ID: 153163

153163

Parent Item: D5380-1

D5380-1

Parent Item Name: Support

Start Date: 12/1/2016

Required Date: 12/1/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV.A NEW ISSUE JFS 16/02/02 VERIFIED BY: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5380-1TRN		Manufactured	No			100	Each	0.0000	0.5	8		DAS 33 9-89	
D5380-1TRN									**				
Support Turning Detail												16/11/18	

M 153165

8

DQA: _____ Date: _____

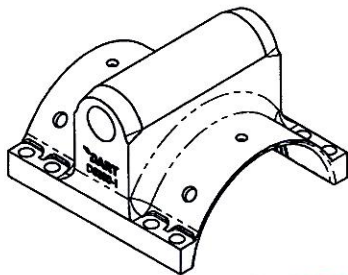


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

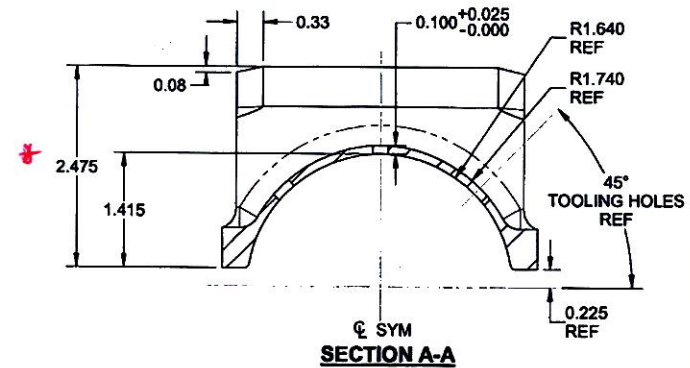
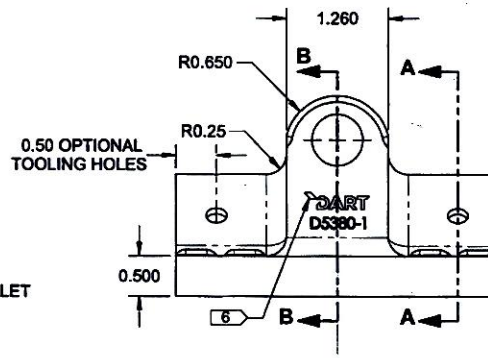
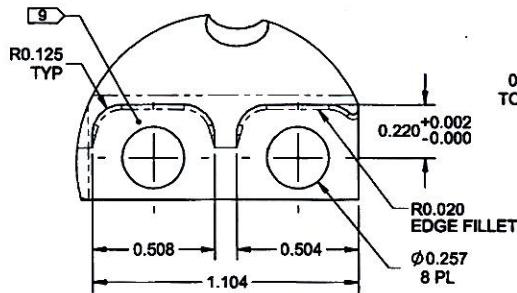
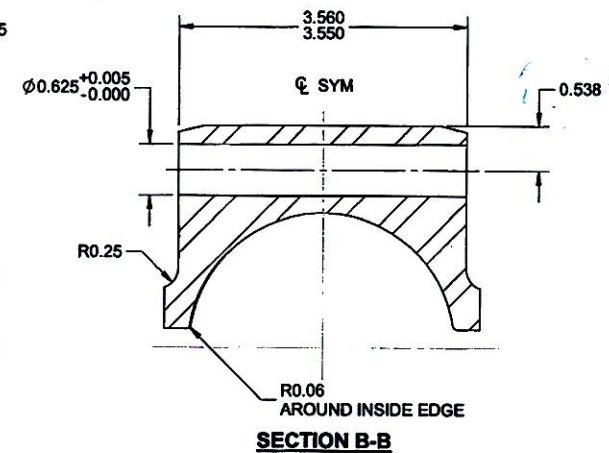
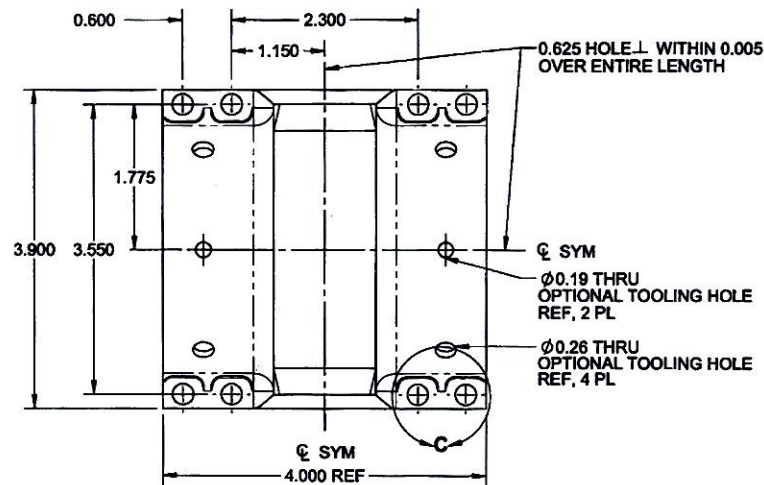
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153163

Em 16/11/8



- NOTES:
- 1) MATERIAL: MAKE FROM D5380-1TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO AND P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 2.08 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-1-REVB.STP"
 - 9) REMOVE MATERIAL FLUSH TO FACE

RELEASED

2016 NOV 08
ECN 16-645

B	MODIFY -1 PROFILE IN DETAIL C, INCREASE HOLE DIAMETER TO 0.257, MODIFY -3 TO ADD CORNER RAD TO CBORE AND INCREASE CBORE DIAMETER; UPDATE NOTES	ML	16.07.07
A	NEW ISSUE	ML	16.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN	ML		
DRAWN	ML		
CHECKED	AJS		
MFG. APPR.	JFS		
APPROVED	WM		
DE APPR.	DS		
DATE	16.07.07		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

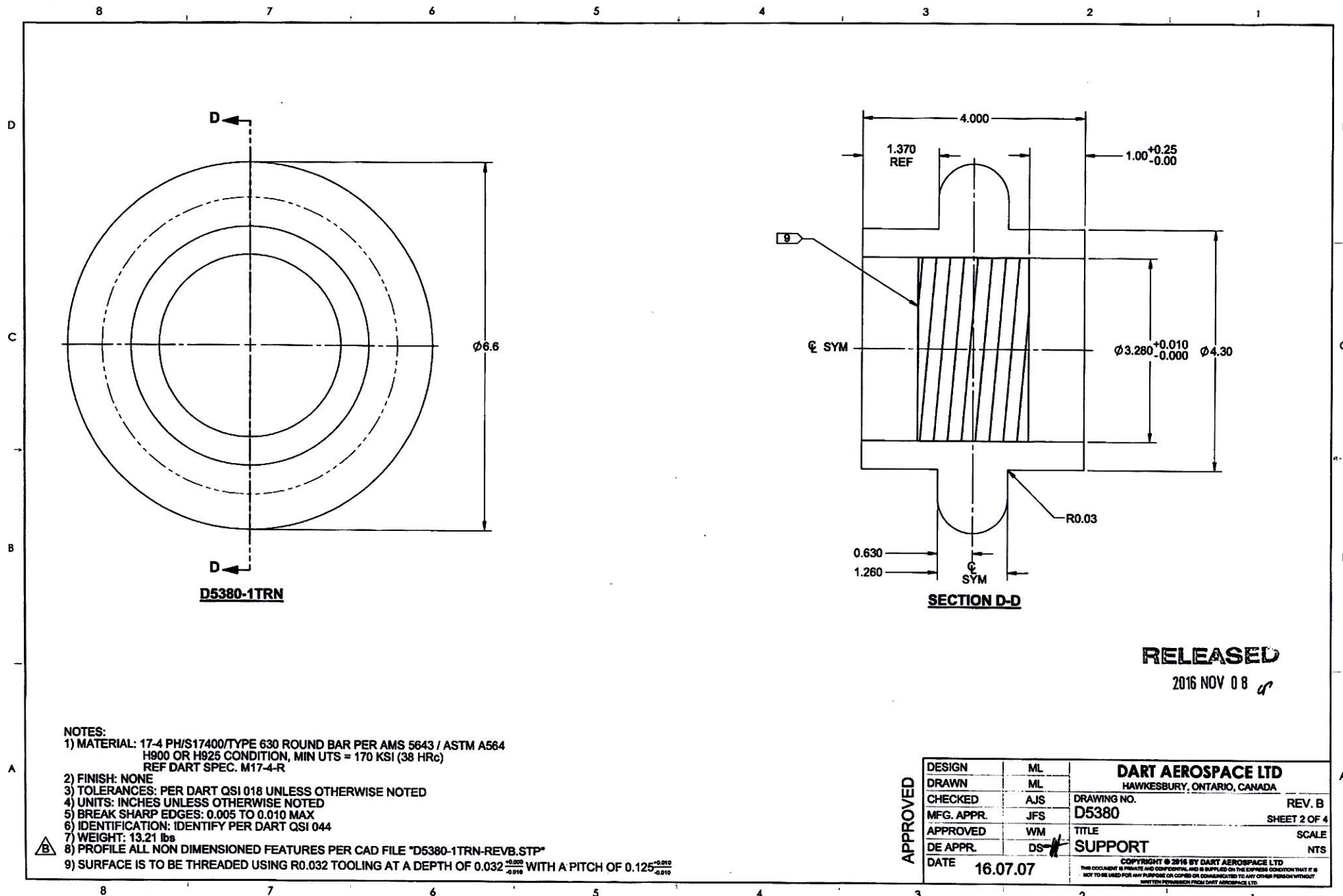
DRAWING NO.
D5380

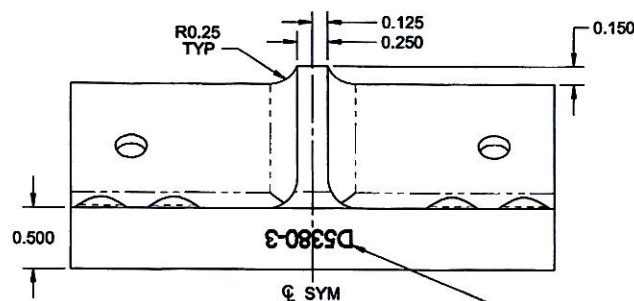
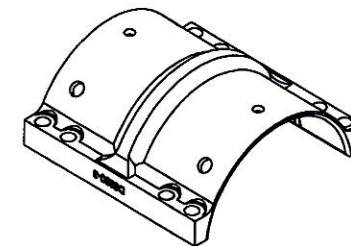
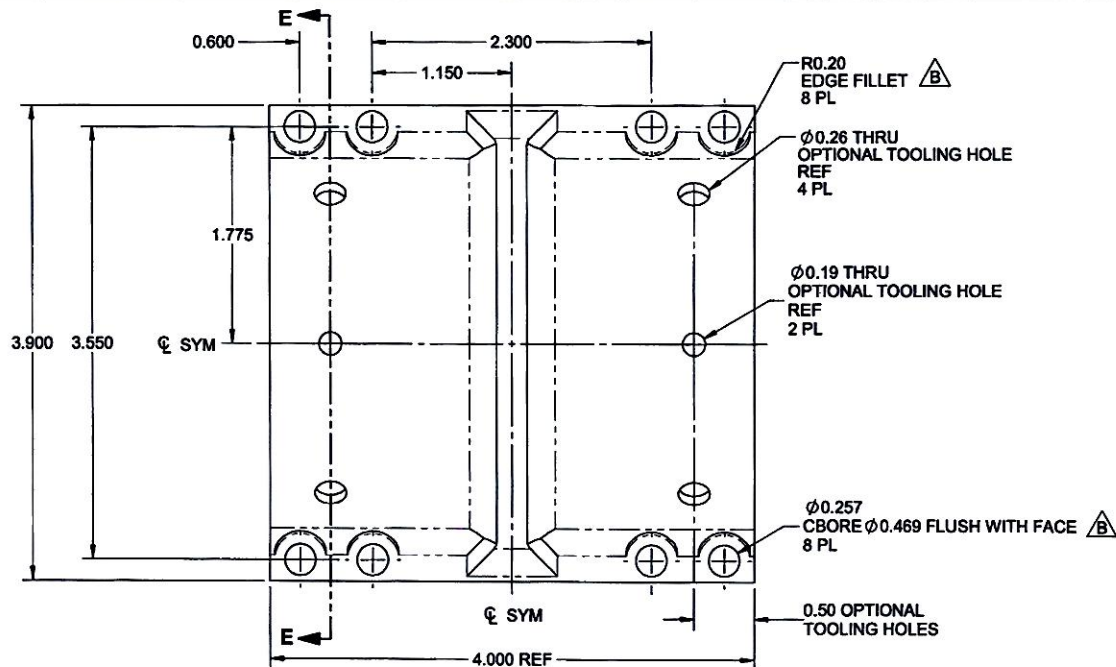
REV. B
SHEET 1 OF 4

TITLE
SUPPORT

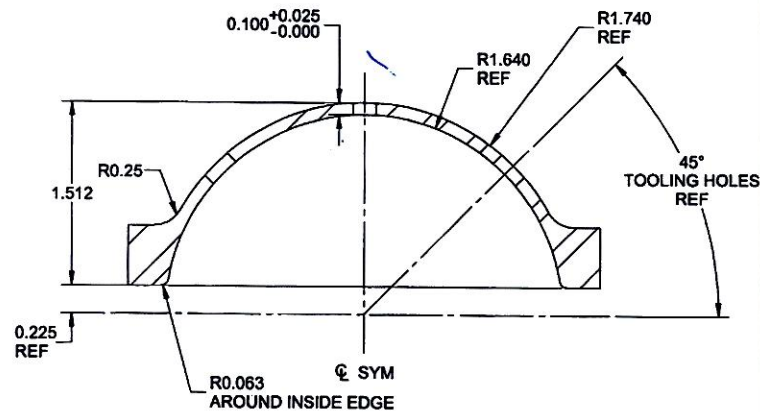
SCALE
NTS

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D5380-3 SUPPORT BASE



SECTION E-E

- NOTES:
- 1) MATERIAL: MAKE FROM D5380-3TRN
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART P/N WITH 0.125 HIGH LETTERING AND 0.005-0.010 DEEP PER DART QSI 044 6.3
 - 7) WEIGHT: 0.89 lbs
 - 8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3-REVB.STP"

RELEASED

2016 NOV 08

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07	COPYRIGHT © 2016 BY DART AEROSPACE LTD	
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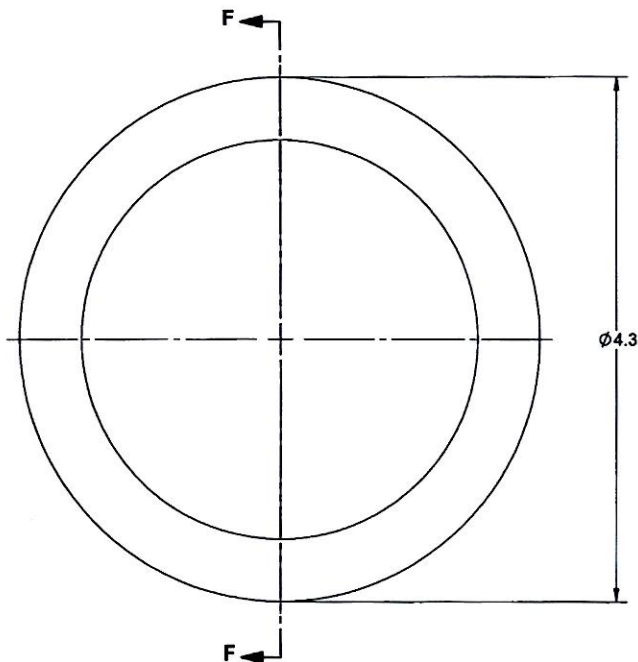
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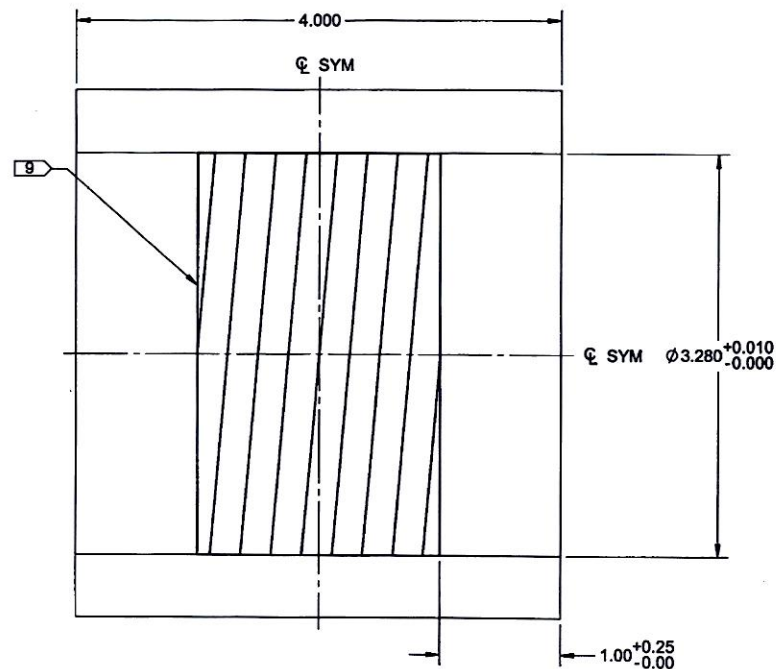
C

B

A



D5380-3TRN



SECTION F-F

NOTES:

1) MATERIAL: 17-4 PH/S17400/TYPE 630 ROUND BAR PER AMS 5643 / ASTM A564
H900 OR H925 CONDITION, MIN UTS = 170 KSI (38 HRC)
REF DART SPEC. M17-4-R

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER DART QSI 044

7) WEIGHT: 7.02 lbs

8) PROFILE ALL NON DIMENSIONED FEATURES PER CAD FILE "D5380-3TRN-REVB.STP"

9) SURFACE IS TO BE THREADED USING R0.032 TOOLING AT A DEPTH OF 0.032^{+0.000/-0.010} WITH A PITCH OF 0.125^{+0.010/-0.010}

RELEASED

2016 NOV 08

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5380	SHEET 4 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SUPPORT	NTS
DATE	16.07.07	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	
Description: Ø Support		Part Number:	05380-1
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				SCRAP 1	SCRAP 2	3	4	5
HAAS Section								
AA	3.810	3.910		3.904	3.904	3.904	3.904	3.904
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.554	3.554	3.554	3.554	3.554
AD	1.765	1.785		1.777	1.777	1.777	1.777	1.777
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.560		3.557	3.557	3.557	3.557	3.557
AI	0.625	0.630		0.628	0.628	0.625	0.625	0.625
AJ	0.528	0.548	see NCR →	0.523	0.524	0.537	0.537	0.537
AK	0.498	0.518	1st page	0.505	0.505	0.505	0.505	0.505
AL	0.494	0.514		0.500	0.500	0.500	0.500	0.500
AM	1.094	1.114		1.099	1.099	1.099	1.099	1.099
AN	0.220	0.222		0.2215	0.222	0.2215	0.2215	0.2215
AO	0.490	0.510		0.499	0.500	0.500	0.500	0.500
AP	1.250	1.270		1.262	1.262	1.262	1.262	1.263
AQ	2.465	2.485	see NCR →	2.462	2.460	2.475	2.475	2.475
AR	1.405	1.425	1st page	1.417	1.419	1.418	1.418	1.418
AS	0.050	0.110		0.075	0.075	0.075	0.075	0.075
AT	0.300	0.360		0.320	0.320	0.320	0.320	0.320
AU	0.100	0.125		0.110	0.111	0.109	0.111	0.109
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.015	0.015	0.015	0.015	0.015
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø " bore is perpendicular to " bore within " Accept/Reject 0.0045" 0.001" 0.0045" 0.003" 0.001"								

Measured by: D.A.	Date: 16-11-19
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø Support		Part Number:	05380-1
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6	7	8	9	10
HAAS Section								
AA	3.890	3.910		3.904	3.904	3.904	3.904	3.904
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.554	3.554	3.554	3.554	3.554
AD	1.765	1.785		1.777	1.777	1.777	1.777	1.777
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.560		3.557	3.557	3.557	3.557	3.557
AI	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AJ	0.528	0.548		0.537	0.537	0.537	0.537	0.537
AK	0.498	0.518		0.505	0.505	0.505	0.505	0.505
AL	0.494	0.514		0.500	0.500	0.500	0.500	0.500
AM	1.094	1.114		1.099	1.099	1.099	1.099	1.099
AN	0.220	0.222		0.2215	0.2215	0.2215	0.2215	0.2215
AO	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AP	1.250	1.270		1.263	1.263	1.263	1.264	1.264
AQ	2.465	2.485		2.475	2.475	2.475	2.475	2.475
AR	1.405	1.425		1.418	1.418	1.422	1.420	1.420
AS	0.050	0.110		0.075	0.075	0.075	0.075	0.075
AT	0.300	0.360		0.320	0.320	0.320	0.320	0.320
AU	0.100	0.125		0.109	0.110	0.110	0.109	0.109
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.015	0.015	0.015	0.015	0.015
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø				" bore is perpendicular to				
				" bore within				
Accept/Reject				0.001"	.001"	.001"	.0025"	.0005"

Measured by: D.A.	Date: 16-11-19
Audited by:	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø Support		Part Number:	05380-1
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
HAAS Section								
AA	3.890	3.910		3.904	3.904	3.904	3.904	3.901
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.554	3.554	3.554	3.554	3.551
AD	1.765	1.785		1.777	1.777	1.777	1.777	1.777
AE	0.590	0.610		0.600	0.600	0.600	0.600	0.600
AF	1.140	1.160		1.150	1.150	1.150	1.150	1.150
AG	2.290	2.310		2.300	2.300	2.300	2.300	2.300
AH	3.550	3.560		3.557	3.557	3.557	3.557	3.557
AI	0.625	0.630		0.625	0.625	0.625	0.625	0.625
AJ	0.528	0.548		0.537	0.537	0.537	0.537	0.537
AK	0.498	0.518		0.505	0.505	0.505	0.505	0.505
AL	0.494	0.514		0.500	0.500	0.500	0.500	0.498
AM	1.094	1.114		1.099	1.099	1.099	1.099	1.099
AN	0.220	0.222		0.2215	0.2215	0.2215	0.2215	0.2201
AO	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AP	1.250	1.270		1.262	1.262	1.262	1.262	1.262
AQ	2.465	2.485		2.475	2.475	2.475	2.475	2.475
AR	1.405	1.425		1.418	1.418	1.417	1.418	1.417
AS	0.050	0.110		0.075	0.075	0.075	0.075	0.075
AT	0.300	0.360		0.320	0.320	0.320	0.320	0.320
AU	0.100	0.125		0.109	0.109	0.109	0.111	0.109
AV	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AW	0.030	0.090		0.060	0.060	0.060	0.060	0.060
AX	0.010	0.030		0.015	0.015	0.015	0.015	0.015
AY	0.115	0.135		0.125	0.125	0.125	0.125	0.125
AZ	0.640	0.660		0.650	0.650	0.650	0.650	0.650
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject				0.000"	0.0015"	0.003"	0.000"	0.0005

Measured by: B.A.	DAS 08 9-89	DAS 33 9-89	Date: 16-11-20
Audited by:			Date:
Preliminary Approval:			Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø Support		Part Number:	05380-1
Inspection Dwg:	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1G	2	3	4	5
HAAS Section								
AA	3,810	3,910		3,900.0				
AB	0,256	0,263		0,257				
AC	3,540	3,560		3,550				
AD	1,765	1,785		1,777				
AE	0,590	0,610		0,600				
AF	1,140	1,160		1,150				
AG	2,290	2,310		2,300				
AH	3,550	3,560		3,555				
AI	0,615	0,630		0,626				
AJ	0,528	0,548		0,538				
AK	0,498	0,518		0,505				
AL	0,494	0,514		0,504				
AM	1,094	1,114		1,104				
AN	0,220	0,222		0,2205				
AO	0,490	0,510		0,500				
AP	1,250	1,270		1,260				
AQ	2,465	2,485		2,475				
AR	1,405	1,425		1,418				
AS	0,050	0,110		0,080				
AT	0,300	0,360		0,300				
AU	0,100	0,125		0,108				
AV	0,220	0,280		0,250				
AW	0,030	0,090		0,060				
AX	0,010	0,030		0,015				
AY	0,115	0,135		0,125				
AZ	0,640	0,660		0,650				
Ensure that Ø " bore is perpendicular to " bore within " Accept/Reject 0,003								

Measured by: B.A.	DAS 08 9-09	DAS 33 9-89	Date: 16-11-21
Audited by:			Date:
Preliminary Approval:			Date:

Rev	Date	Change	Revised by	Approved
A	08.04.24	New Issue	KJ/JLM	
B	12.07.31	Prototype revised to preliminary	KJ	